

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005104**Date Inspected:** 28-Dec-2008**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Japan Steel Works**OSM Arrival Time:** 830**OSM Departure Time:** 1530**Location:** Muroran, Japan**CWI Name:** Chung Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

Steel Structure Welding Shop:

Tower Saddle Steel Structure (Grillage) T1-3:- Caltrans Quality Assurance Inspector (QAI) representative observed Japan Steel Works (JSW) two welders performed Flux Cored Arc Welding (FCAW) processes on a rib plate weld #9Y-7V (3-2) and #9Y-8V (3-3) of T1-3 tower saddle steel structure (grillage). The two welds start welding from 70% weld metal to 100%. The filler metal and shield gas used in the test for FCAW is Hoballoy wire TM-95K2, 1.6 diameter with 100% C02 made by Hobart Brothers, USA. The parameters used for FCAW welding of assemblies were conducted in accordance with Caltrans approved WPS #SJ-3012-3. The FCAW welding process and parameters have been monitored and recorded by CWI inspector Mr. Chung Kuan. Based on Caltrans QA observation, the FCAW welding operation appeared to be in general compliance with requirements of AWS D1.5 2002 and Caltrans contract documents. The welding has been stop afternoon during to JSW work has wrapped up the shop for one week New Year Holiday.

Summary of Conversations:

As noted within the report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510)385-5910, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By: Pau,Wai

Quality Assurance Inspector

Reviewed By: Lanz,Joe

QA Reviewer